

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-010032**Date Inspected:** 07-Nov-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Xu Yumin and Wu Zhi Cheng**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Joe Alaniz was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

OBG Assembly Yard

This QA inspector performed MT of approximately 15% of the repaired area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT report for this date. The member(s) is/are identified as OBG 2BW LD and Punch List Item 1614. The weld designations reviewed are as follows:

2BW

1. LD011-001-012

1AW+1BW

1. LD23A+LD27A

1AAE+1AE

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SMAW repair welding on excavation on weld joint 003 located on OBE1A.

Welder is identified as Mr. Zang Yanbo (045196). ZPMC QC is identified as Wu Li Yang.

The welding variables recorded by QC appeared to comply with WPS-345-SMAW-4G (4F)-FCM-Repair-1 and CWR repair procedure #868.

Y location of excavation areas noted welder (045196) performed the repair work is at 840mm and 850mm of the bottom plate and cross beam weld joint.

1AW+1AAW

SMAW repair welding on excavation on weld joint 007 located on OBW1A.

Welder is identified as Mr. Feng Huajun (066258). ZPMC QC is identified as Xu Yumin.

The welding variables recorded by QC appeared to comply with WPS-345-SMAW-4G (4F)-FCM-Repair-1. CWR repair procedure for UT retest repair is pending.

Y location of excavation areas noted welder (066258) performed the repair work is at 3195mm of the side plate and bottom plate weld joint.

1AE

This QA Inspector performed Magnetic Particle (MT) inspection of weld joint CA107-004 excavation performed by ZPMC. MT inspection was performed at the deck panel to edge plate (cross beam side) prior to ZPMC MT inspection. Y locations and number of MT indication are as followed:

1. Y location 10,550mm and slag is present in excavation.
2. Y location 9315mm and slag is present in excavation.
3. Y location 8880mm and 1 transverse indication is present in excavation.
4. Y location 7440mm and slag is present in excavation.
5. Y location 6630mm and slag is present in excavation.

This QA Inspector performed Magnetic Particle (MT) inspection of weld joint SEG2F-002 excavation performed by ZPMC. MT inspection was performed at the deck panel to edge plate (cross beam side) prior to ZPMC MT inspection. Y locations and number of MT indication are as followed:

6. Y location 1685mm and 1 transverse indication is present in excavation.
7. Y location 360mm and slag is present in excavation.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract

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documents.

Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang (134-8257-0045), who represents the Office of Structural Materials for your project.

Inspected By:	Alaniz,Joe	Quality Assurance Inspector
Reviewed By:	Carreon,Albert	QA Reviewer
